

Date: Monday, 3/17/2008 11:57:03 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH BRACKET
Job Number	: 38032		
Estimate Number	: 10994		
P.O. Number	:	Part Number	: D2583
This Issue	: 3/17/2008 S.O. No. :	Drawing Number	: D2583 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 36043	Material	:
Written By	:	Due Date	: 4/10/2008 Qty: 100 Um: Each
Checked & Approved By	:		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM		
	Est: D 06.07.21 Waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S040)

Batch: 107513 B 8-3-25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2583

Dwg Rev: B

Prog Rev: B

B 8-3-25

(109)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-3-25

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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B 8-3-25

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr

Form on CNC Brake as per Dwg D2583

B 8-3-25

(109)

08/04/01

(109)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:57:03 AM
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Process Sheet

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Drawing Name: LATCH BRACKET

Job Number: 38032

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



DSP017



counts

Comment: INSPECT WORK TO CURRENT STEP

08/04/07 (+105)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/04/07

(105)

8.0

POWDER COATING

POWDER COATING



M 107550



(108)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 08/04/08

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/04/08

(108)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST222

FL 08/04/08

X108

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/10

Job Completion



mf 08-04-09

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

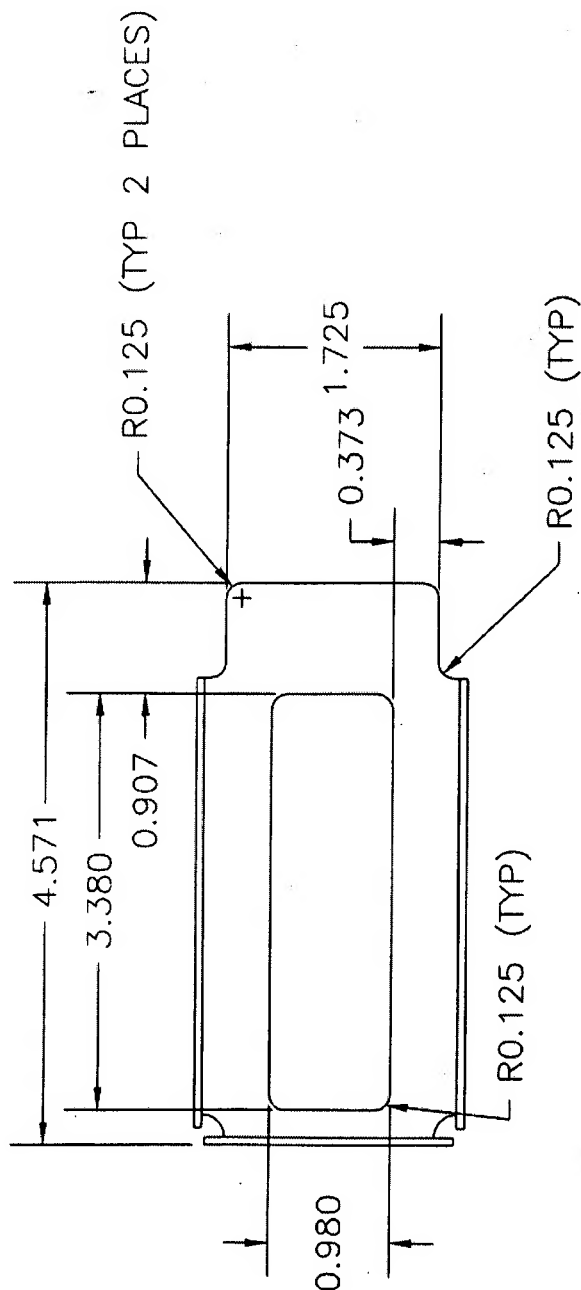
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

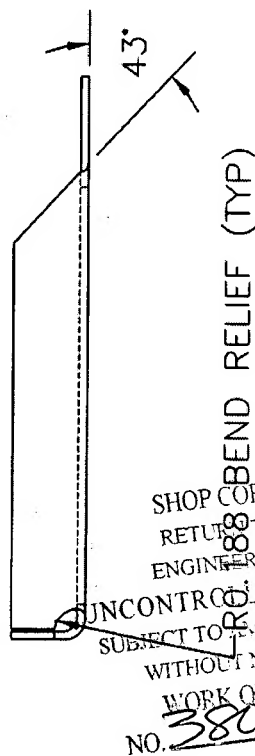
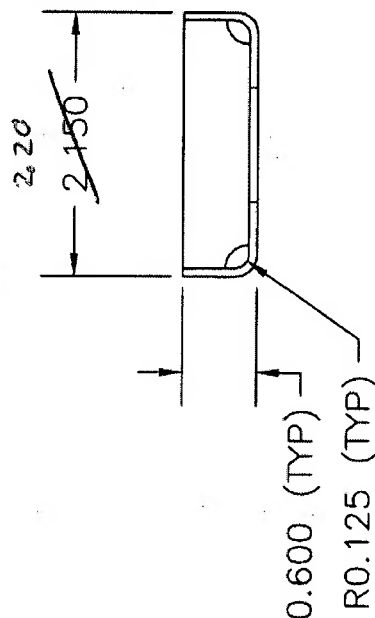


DESIGN MIKE M.	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED QP	APPROVED KE	DRAWING NO. D2583	REV. B SHEET 1 OF 1
DATE 99.02.22	TITLE LATCH BRACKET		SCALE 2:3
A	96.07.10	NEW ISSUE	
B	99.02.22	CHANGE OF FINISH (PER TSR A887)	

RELEASED
KE 99.02.25



KE 99.02.26



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO REVISION
WITHOUT NOTICE
WORK ORDER
NO. 38032

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED